

Date: Wednesday, 28/01/2009 1:13:42 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BASKET BASE ASSEMBLY (350)
<b>Job Number</b> :	45359C		
<b>Estimate Number</b> :	10189		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2221
<b>This Issue</b> :	28/01/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2221 REV H
<b>First Issue</b> :	///	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	44873A	<b>Drawing Revision</b> :	H
	<b>Type</b> :	<b>Material</b> :	
	LARGE FAB ASSY	<b>Due Date</b> :	04/02/2009
<b>Written By</b> :		<b>Qty:</b>	1
<b>Checked &amp; Approved By</b> :	<u>JUD 09-01-28</u>	<b>Um:</b>	Each
<b>Comment</b> :	Est Rev:J 05.09.02 Added D3442-1 KJ/JLM Est Rev:K 08-08-29 revG as per dwg DD verified by:EC Est Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC Est Rev:M 08-12-02 revH as per dwg DD verified by:		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D22211	Rib
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib

batch: B43982

PD 09-02-03

2.0	D22215	Rib
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib

batch: B43983

PD 09-02-03

3.0	D22217	Rib
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib

batch: B44753

PD 09-02-03

4.0	D22323	Basket Hinge
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

batch: B42075

PD 09-02-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 45359C

Part Number: D2221

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

D22351

Basket Rib



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Basket Rib

batch: 644046

*Handwritten:* Island - #44010

PD 09-02-03

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Mounting Bracket

batch: 643800

PD 09-02-03

7.0

D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Shim

batch: 640392

PD 09-02-03

8.0

D3825041

Rib Assembly (Basket End)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rib Assembly (Basket End)

batch: 644009

PD 09-02-03

9.0

D3826041

Rib / Gusset Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rib / Gusset Assembly

batch: 644010

PD 09-02-03

10.0

D3827041

Rib Assembly (Inboard)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Rib Assembly (Inboard)

batch: 644011

PD 09-02-03

11.0

D38331

Mesh (Base End Face)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Mesh (Base End Face)

batch: 644015

PD 09-02-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 45359C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D38321

Mesh (Base)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Mesh (Base)

batch: 844012

PD 09-02-03

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221

2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221

3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch: M107051

PD 9-2-3

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PC09-02-04

15.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

809/02/05 (X)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Plug holes prior to powder coating

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M109096

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

SR 09-02-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 45359C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/02/12 (X)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17 J

Job Completion



MF 09-0213

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

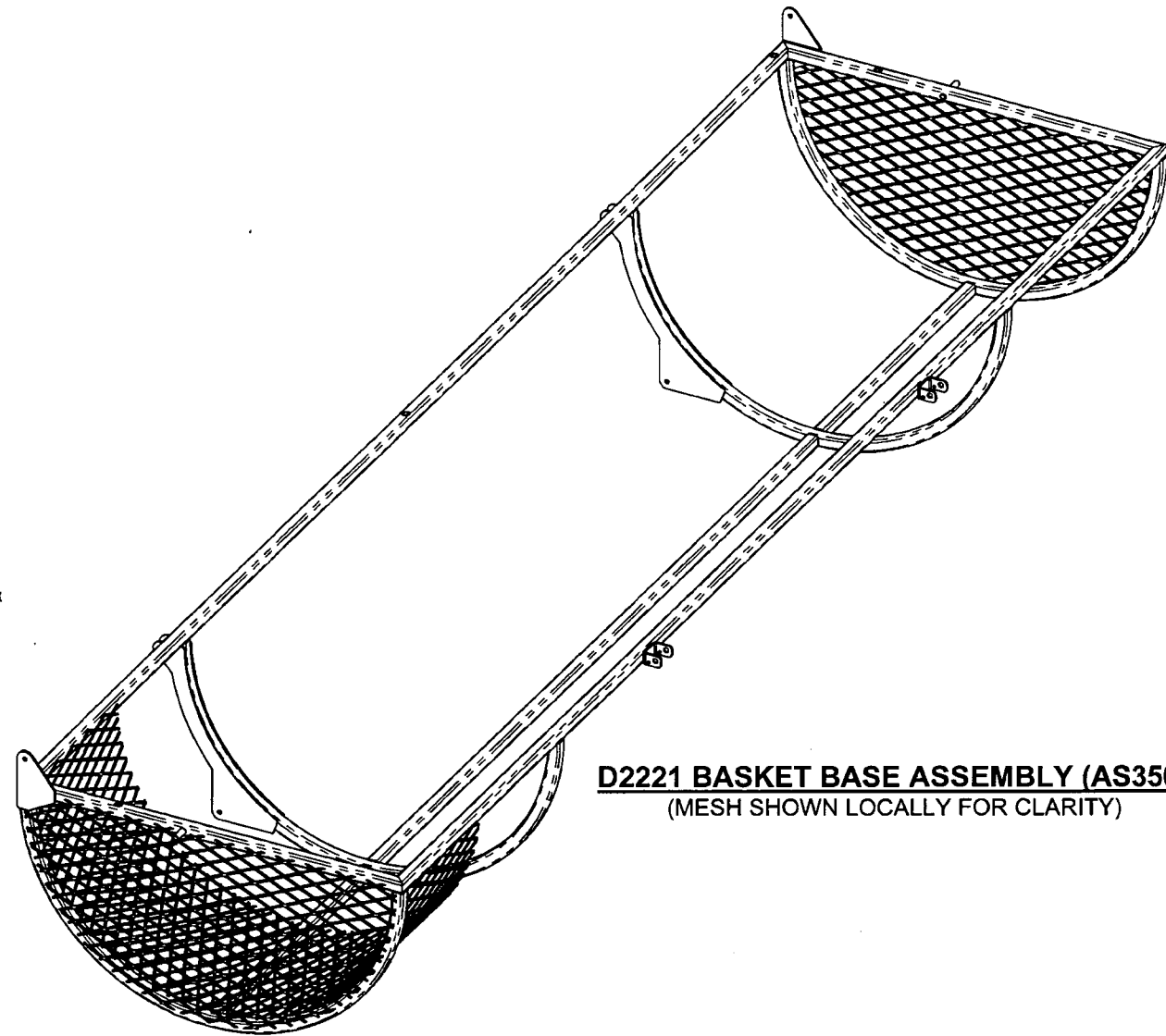
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING



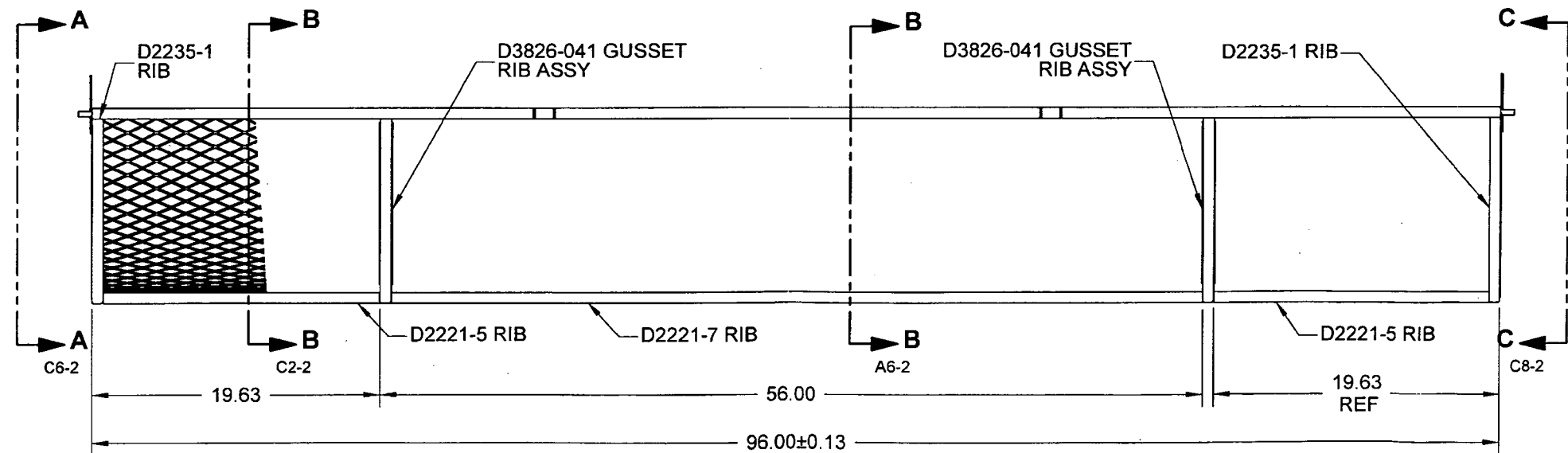
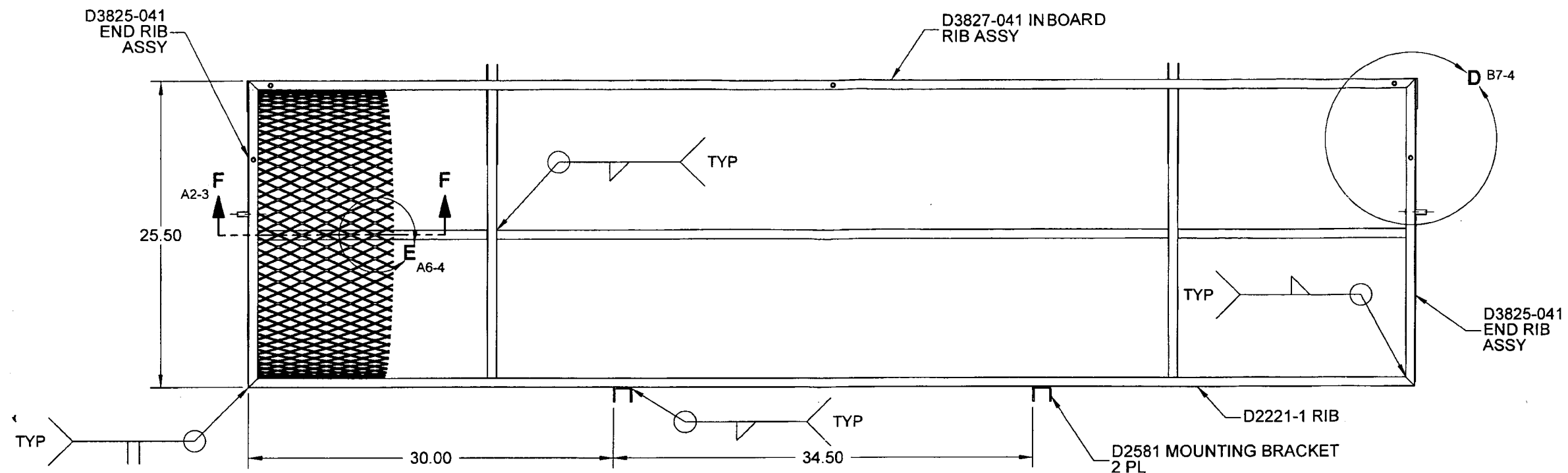
ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

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08/11/18

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453916

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	ISS	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

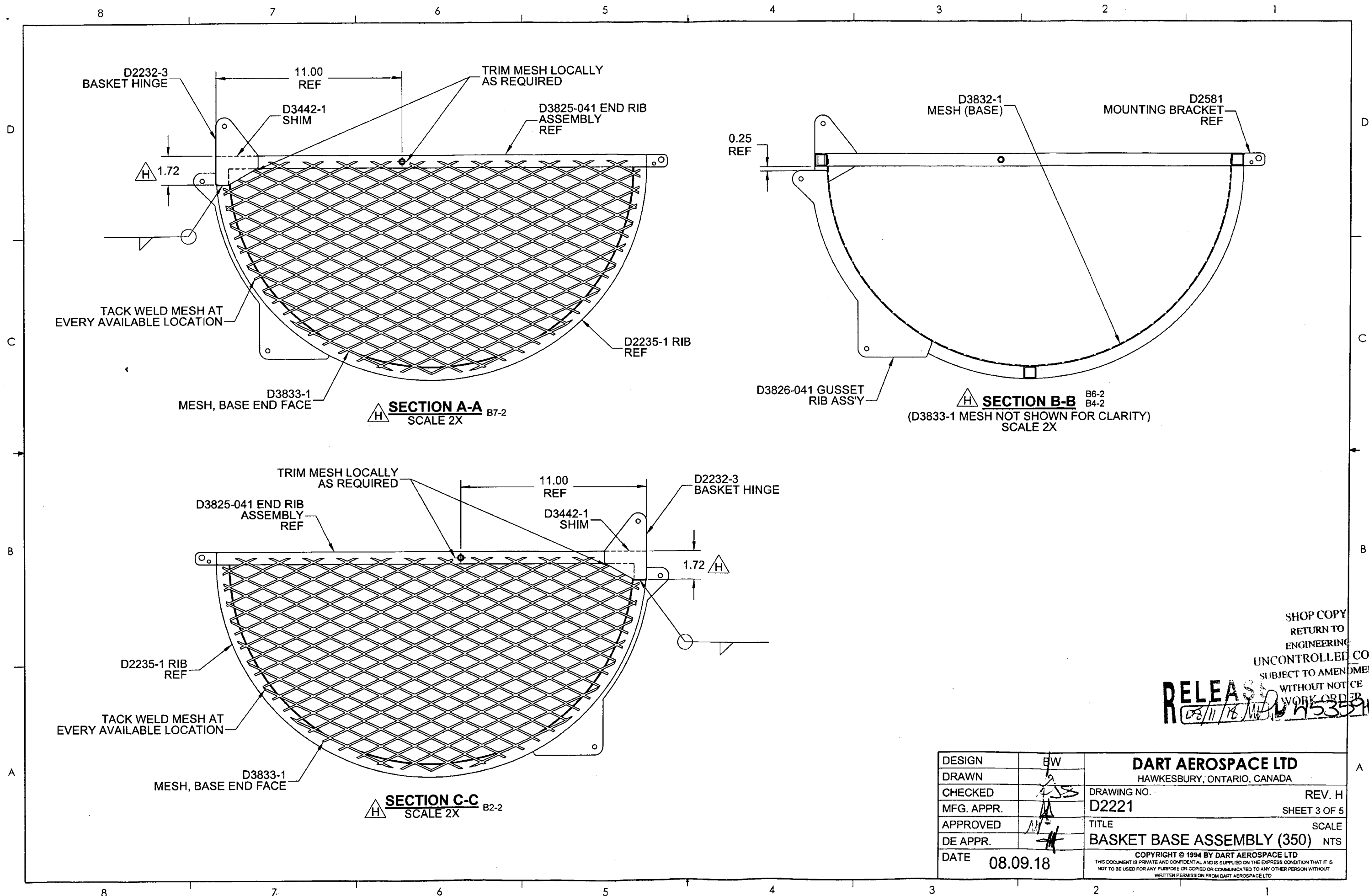


**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

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06/11/18 NWD

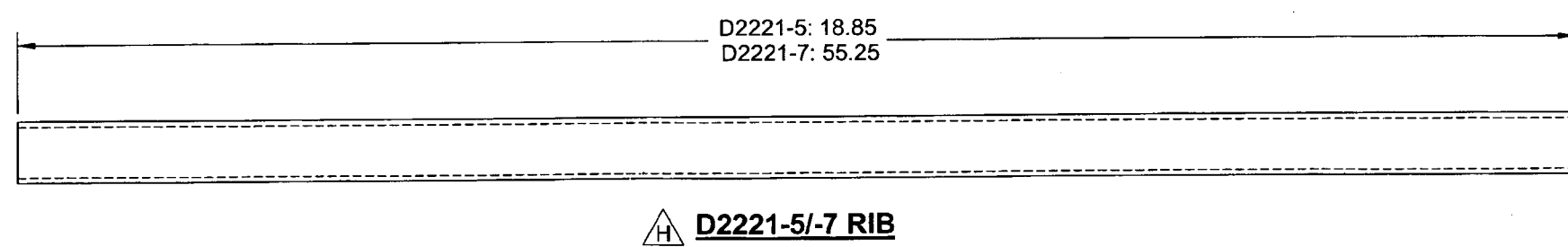
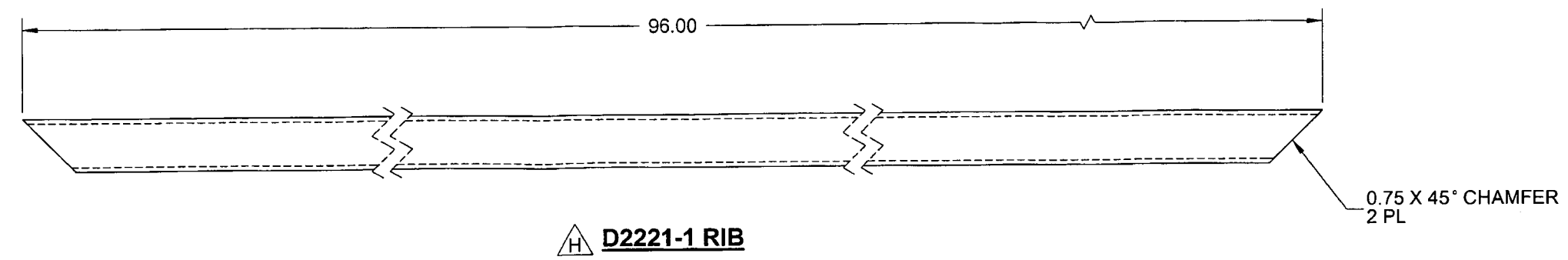
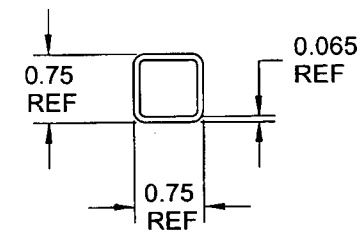
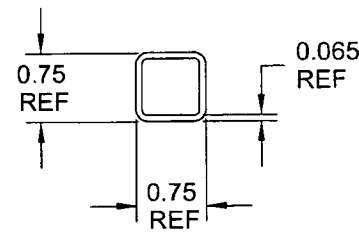
DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D2221</b>	REV. H
MFG. APPR.		SHEET 2 OF 5	
APPROVED		TITLE <b>BASKET BASE ASSEMBLY (350)</b>	SCALE NTS
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08/11/18 M5351E

DESIGN	EW	<b>DART AEROSPACE LTD</b>	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JSB	DRAWING NO. <b>D2221</b>	REV. H
MFG. APPR.	A	SHEET 3 OF 5	
APPROVED	M	TITLE	SCALE
DE APPR.	H	<b>BASKET BASE ASSEMBLY (350)</b>	NTS
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- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	MD	D2221	SHEET 5 OF 5
APPROVED	W	TITLE	SCALE
DE APPR.	SH	<b>BASKET BASE ASSEMBLY (350)</b> NTS	
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